



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

*MUST SHIP
YAW 30*

D5467-1
Job Sheet 171078



Part No: D5467-1

Job Qty: 2 ea

Part Name: Saddle, Fwd, Out



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/26/18

Job Tracking No:

Due Date: 1/30/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: IPP Rev.A 17.07.12 New issue DP Verify DD IPP REV:B 17.11.03 AS PER DWG REV.A DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	1/29/18	1/29/18	0.00	0.00	Start Up Machining-4		FK 18-1-28
100	CNC Vertical Machining	2 pcs	1/29/18	1/29/18	0.00	2.80	HAAS1-1		FK 18-1-28
120	QC	2 pcs	1/29/18	1/29/18	0.00	0.00	QC1		FK 18-1-28
130	QC	2 pcs	1/29/18	1/29/18	0.00	0.00	QC8 Machining-4		A.P 18-01-30
140	HandFinish	2 pcs	1/29/18	1/29/18	0.00	0.60	HandFinish1		2018/01/30 J.L
150	SprayPaint	2 pcs	1/30/18	1/30/18	0.00	0.05	Spray Paint		PO 13-03-08
160	QC	2 pcs	1/30/18	1/30/18	0.00	0.00	QC14		PD 18-01-31
170	Packaging	2 pcs	1/30/18	1/30/18	0.00	0.00	Packaging3-2		PD 13-01-31
180	QC21-SA	2 Ea	1/30/18	1/30/18	0.00	0.00	QC21		FEB 01 2018

Part Op 100 - Program Batch No. 5036214 Double check by: A.P 1-Machine Step No 1 per Folio FB550 and inspect per Descriptions: attached Dimension Sheets 2-Machine Step No 2 per Folio FB550 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FB550 and inspect
120 - Inspect on CMM as per folio CMMA022. DWG REV: _____ CMM PROG. REV: _____
150 - ***MASK HOLES PRIOR TO PRIME AND PAINT AS PER DWG NOTE 9*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: _____ 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT BATCH: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-007	Saddle Billet	2 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-007	2	16	0
	<u>5036212</u>			

Part Specifications

Specifications could not be found.

PO 1038908

JAN 30 2018

DAS
13
9-08

Plex 1/26/18 2:50 PM dart.lacelle.linda

DART
AEROSPACE
S036214

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CANADA
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Saddle, Fwd, Out

PART NO: D5467 - 1

Original Serial #: S036214

Revision:

Operation:

Change No:

Start up Operation 01/28/18

Job No: 171078

DART AEROSPACE LTD	Work Order: 171078
Description: Saddle, Fwd Outboard	Part Number: D2571 DS467-1
Inspection Dwg: D2571 Rev. A	Page 1 of 1

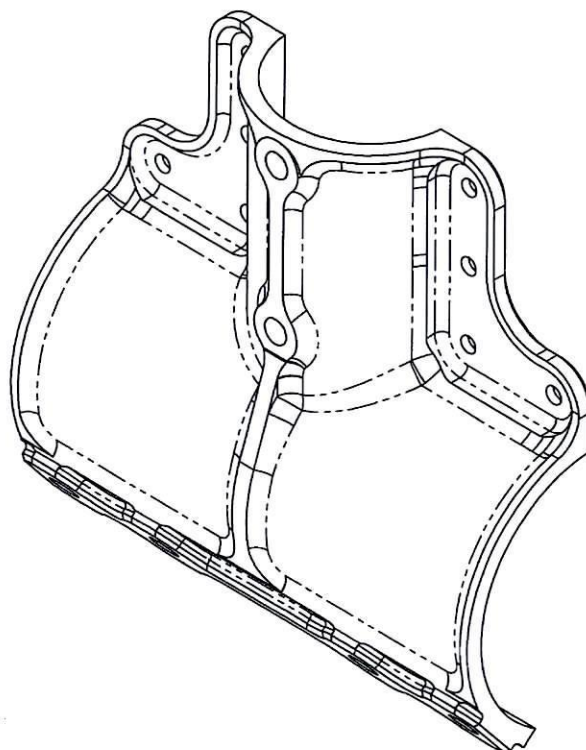
Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.438	.438				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.000	8.000				
F	0.490	0.510		.501	.501				
G	0.257	0.262		.257	.257				
H	0.375	0.380		.377	.377				
I	0.490	0.510		.500	.500				
J	1.174	1.184		1.179	1.179				
K	0.558	0.578		.568	.568				
L	1.174	1.184		1.179	1.179				
M	1.490	1.500		1.495	1.495				
N	2.495	2.505		2.500	2.500				
O	3.869	3.879		3.874	3.874				
P	0.115	0.135		.135	.135				
Q	0.115	0.135		.125	.125				
R	0.240	0.260		.251	.252				
S	0.115	0.135		.126	.125				
T	0.178	0.198		.188	.188				
U	2.940	2.980		2.960	2.960				
V	0.230	0.250		.239	.239				
W	0.115	0.135	.119	.121	.121				
X	0.308	0.343							
Y	0.760	0.765							
Z	0.352	0.372		.365	.365				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.625	.625				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.249	.250				
AE	1.375	1.395		1.385	1.385				
AF	0.115	0.135		.125	.125				
AG	0.240	0.280		.265	.265				
AH	0.240	0.260		.250	.250				
AI	2.000	2.020		2.000	2.000				
AJ	0.023	0.043							
Accept/Reject									

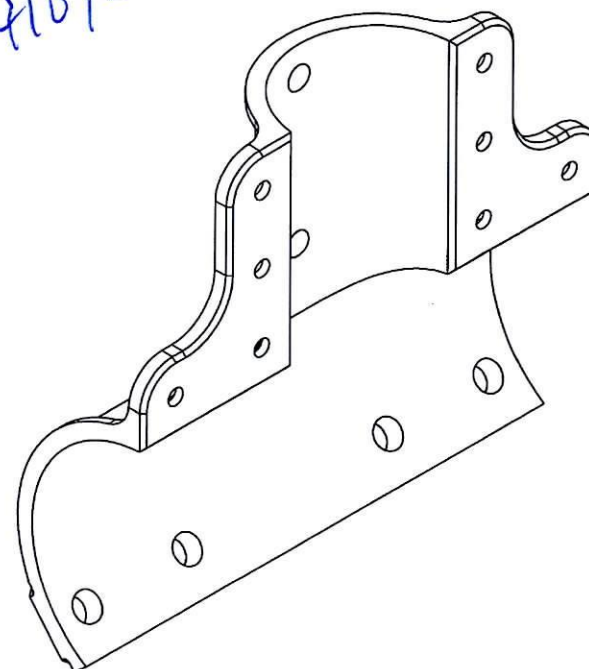
Measured by: EK / SBL
Date: 18-1-29 / 18-01-30

Audited by: G.P
Date: 18-01-30

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	



171078



D5467-1 OUTER FWD SADDLE

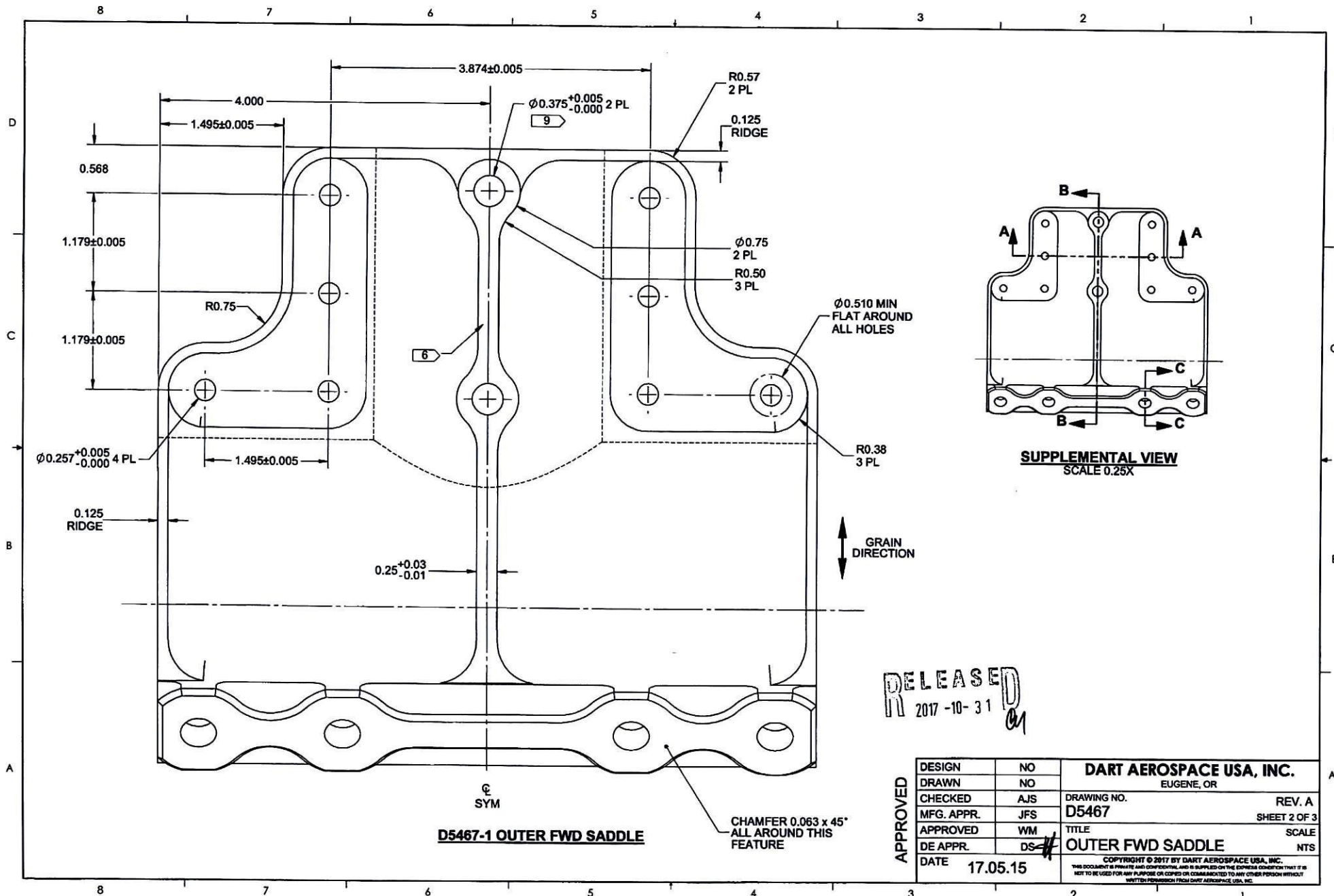
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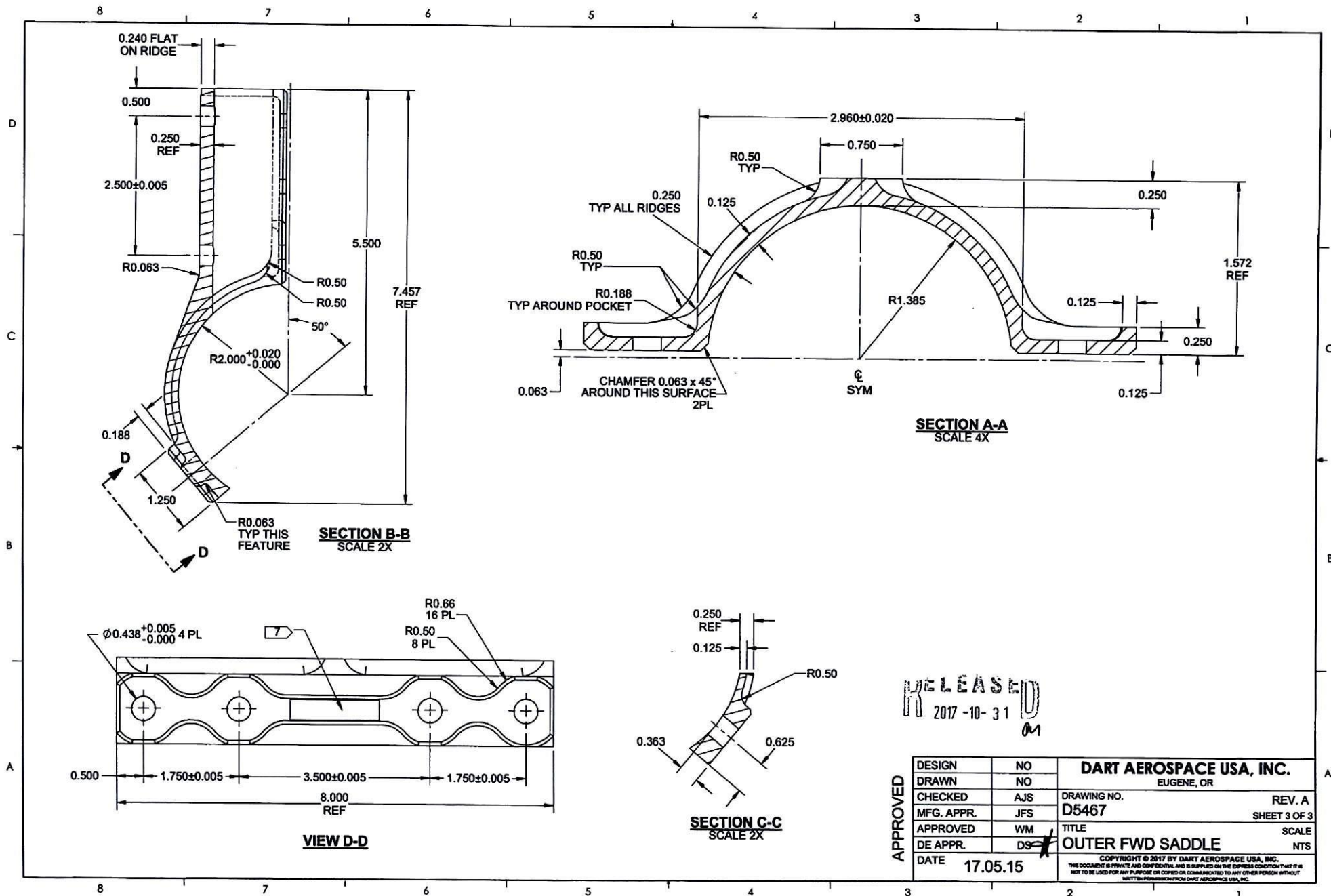
- 1) MATERIAL: 7075-T7351 PER QQ-A-250/12
REF DART SPEC. D6101-007
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME PER DART QSI 005 4.2.1.3.3
PAINT PER DART QSI 005 4.2.2.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5467-1" & BATCH NUMBER PER QSI 044 6.3
USE MAX DEPTH OF 0.010 WITH MIN TOOL RAD OF 0.010
- 7) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD OF 0.125
- 8) WEIGHT: 1.07 lbs
- 9) MASK THESE HOLES PRIOR TO PAINT

RELEASED
2017-10-31
EN 11-78

APPROVED

A		NEW ISSUE		NO	17.05.15
REV.	DESCRIPTION			BY	DATE
DESIGN	NO	DART AEROSPACE USA, INC. EUGENE, OR			
DRAWN	NO				
CHECKED	AJS	DRAWING NO.	REV. A		
MFG. APPR.	JFS	D5467	SHEET 1 OF 3		
APPROVED	WM	TITLE	SCALE		
DE APPR.	DS	OUTER FWD SADDLE	NTS		
DATE	17.05.15	COPYRIGHT © 2017 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			







Dart Hawkesbury
1270 Aberdeen St Hawkesbury, ON K6A 1K7 Canada
Tel (613) 632-5200

Purchasing Receipts

PO No	Supplier	Line Item No	Rel No	Terms	Purchased Item	Description	For Part No	Project	Equipment ID	Order Qty	Due Date	Received Quantity	Accounting Job No	Serial No	Status	Receive Date	Price/Unit	Aging Days	Past Due	Total	Suppl Nam	
PO038908	ATE003-VC	1	1	Net 30	OUTSIDE SERVICES	paint white D5425-043 job 168535				1	1/31/2018	1			Inactive	1/31/2018	\$ 225.00 / Ea	0		\$225.00	Atelier Deboss	
		2								1		Inactive	1/31/2018	\$ 225.00 / Ea	0		\$225.00	Atelier Deboss				
		3							2		2		Inactive	1/31/2018	\$ 25.00 / Ea	0		\$50.00	Atelier Deboss			
		4									2		Inactive	1/31/2018	\$ 25.00 / Ea	0		\$50.00	Atelier Deboss			
		5									2		Inactive	1/31/2018	\$ 25.00 / Ea	0		\$50.00	Atelier Deboss			
		6									2		Inactive	1/31/2018	\$ 25.00 / Ea	0		\$50.00	Atelier Deboss			
Total:										10		10									\$528.00	

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038908

Supplier: ATE003-VC
Atelier Debosselage
358 Principale
Calumet
QC
J0V 1B0 Canada
Phone: 819 242 5633

PO No: PO038908
PO Date: 1/30/18
Due Date: 1/31/18
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Lavoie, Chantal
Phone: clavoie@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1		Paint	OUTSIDE SERVICES	paint white D5425-043 job 168535	Firmed	1/31/18	1 Ea	0 Ea	1 Ea	\$225.00/Ea	\$225.00
2		Paint	OUTSIDE SERVICES	paint white D5425-043 job 170125	Firmed	1/31/18	1 Ea	0 Ea	1 Ea	\$225.00/Ea	\$225.00
3		Paint	OUTSIDE SERVICES	paint white D5466-1 job 171077	Firmed	1/31/18	2 Ea	0 Ea	2 Ea	\$25.00/Ea	\$50.00
4		Paint	OUTSIDE SERVICES	paint white D5469-1 job 171080	Firmed	1/31/18	2 Ea	0 Ea	2 Ea	\$25.00/Ea	\$50.00
5		Paint	OUTSIDE SERVICES	paint white D5468-1 job 171079	Firmed	1/31/18	2 Ea	0 Ea	2 Ea	\$25.00/Ea	\$50.00
6		Paint	OUTSIDE SERVICES	paint white D5467-1 job 171078	Firmed	1/31/18	2 Ea	0 Ea	2 Ea	\$25.00/Ea	\$50.00
Grand Total:										\$650.00	

Order Notes

CL

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